

WEEK 36

Work Order ID 165247

165247

Page 1

Thursday, August 17, 2017 10:36:59 AM

Item ID: D3914-7 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Rib

Start Date: 8/17/2017 Start Qty: 8.00 *8* Cust Item ID:

Required Date: 8/18/2017 Req'd Qty: 8.00 *8* Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: AUG 17 2017 Tooling: _____ Date: _____ Run Start *NR1*

QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3914	D								
100		0.00							
100									
Large Fab	Memo	1.20							
Large Fab	1- Cut tube as per dwg D3914 2- debur and remove identification markings								
110	QC6- All purchased or subcontracted products	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>W204</u>	0.00							
120									
Packaging	Memo	0.08							
Packaging	LOCATION: WA004								

8x D.M.L. 2017-8-21

8x D.M.L. 2017-8-24

DAS
38
9-89

AUG 24 2017

8x D.M.L. 2017-8-24

Work Order ID 165247

Thursday, August 17, 2017 10:36:59 AM

165247

Page 2

Item ID: D3914-7 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Rib
Start Date: 8/17/2017 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 8/18/2017 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.80							
Quality Control									

DAS
21
9-88

AUG 25 2017

Picklist Print

Thursday, August 17, 2017 10:37:02 AM

Page 1

Work Order ID: 165247

165247

Parent Item: D3914-7

D3914-7

Parent Item Name: Rib

Start Date: 8/17/2017

Required Date: 8/18/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as
per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 11.01.18 chg
qc5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049		Purchased				100	f	739.3468	7.875	66.31579			
M304TS0 500W 049									**				
Square Tubing													

D.M.L 2017-8-21

Location

Loc Qty

Loc Code

WA004

739.34684

137992

467

M136011

4.64684

M137257

30.5

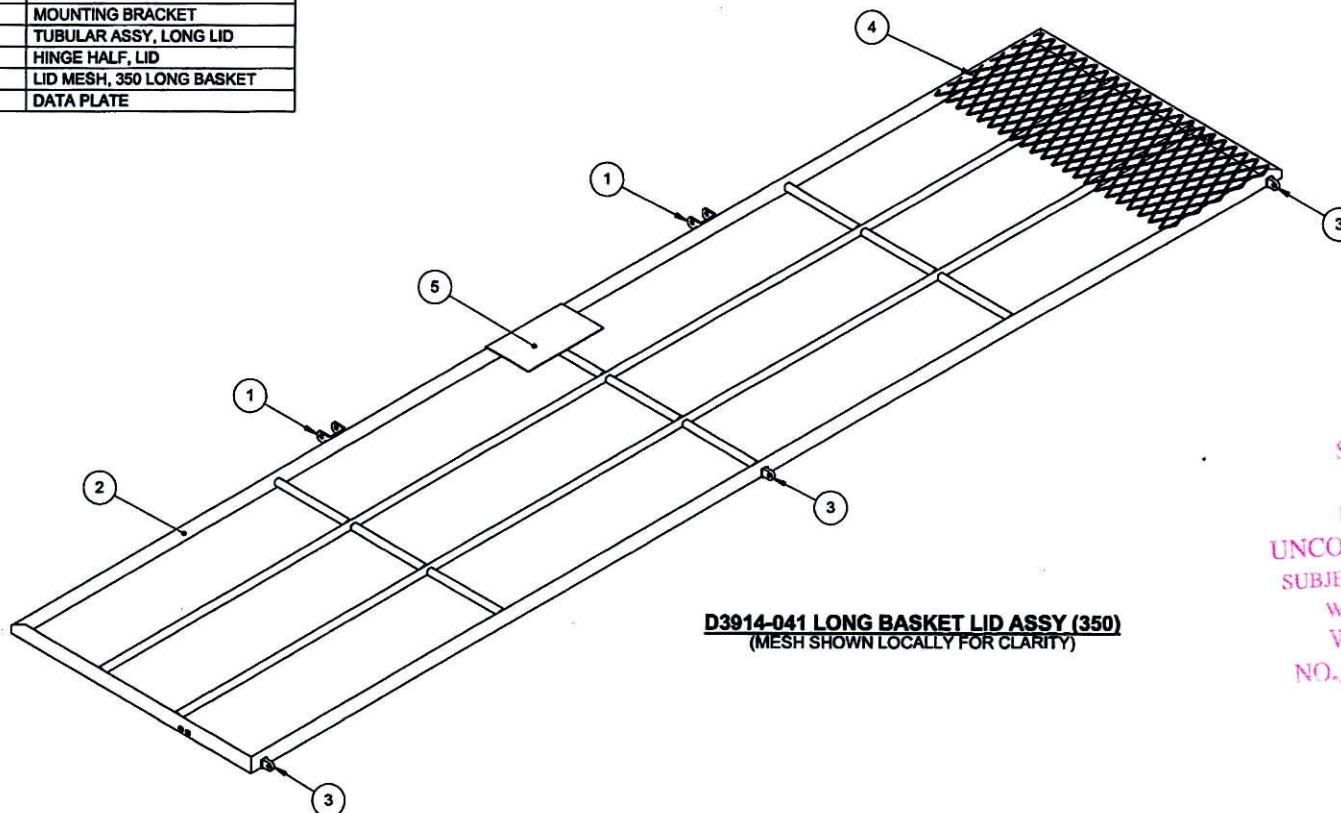
M137992

104.2

M138186

600

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	1	D3914-101	TUBULAR ASSY, LONG LID
3	3	D4016-3	HINGE HALF, LID
4	1	D4020-5	LID MESH, 350 LONG BASKET
5	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165247 MJS
1708-17

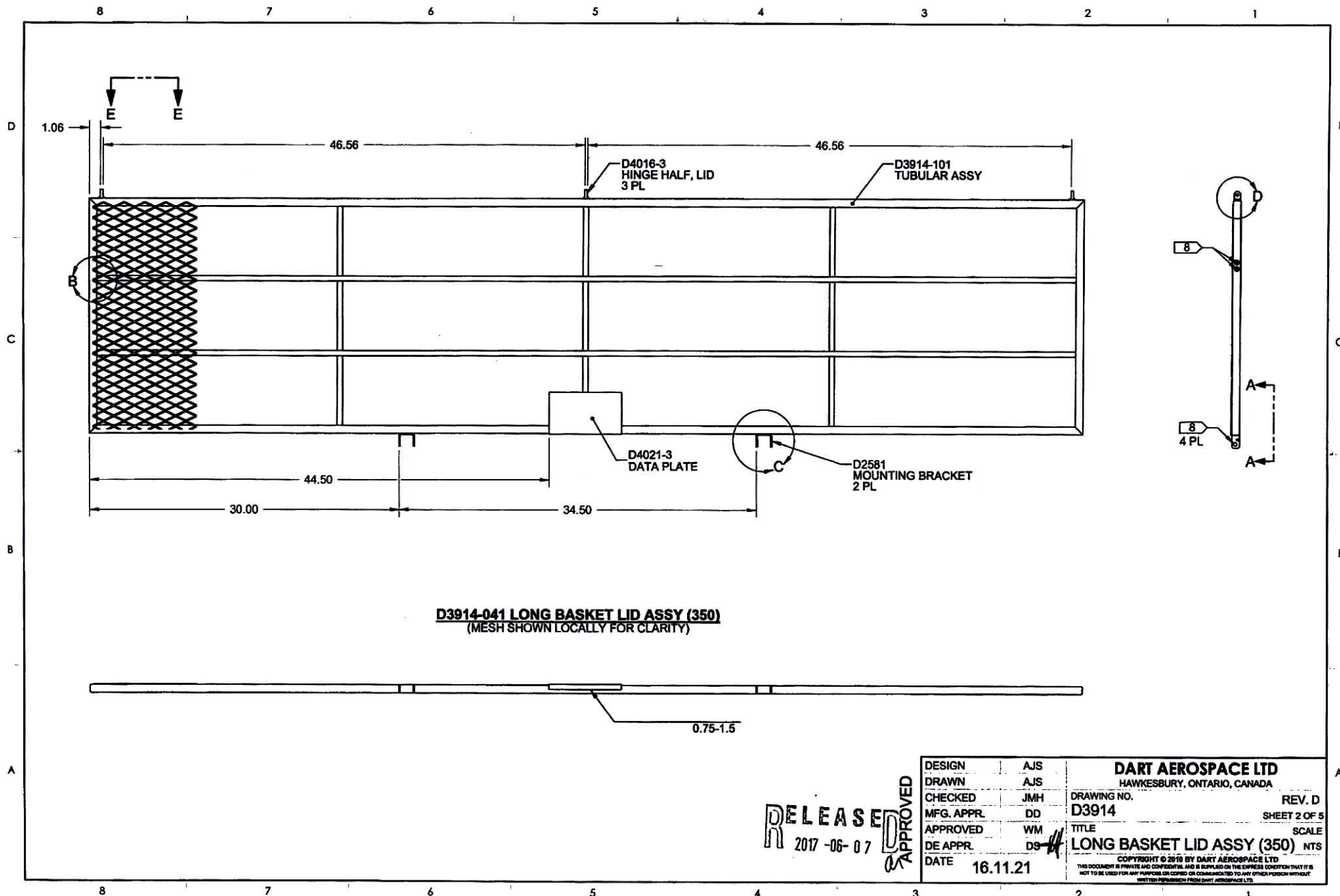
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N AND B/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004
- 10) MASK THIS AREA PRIOR TO FINISH

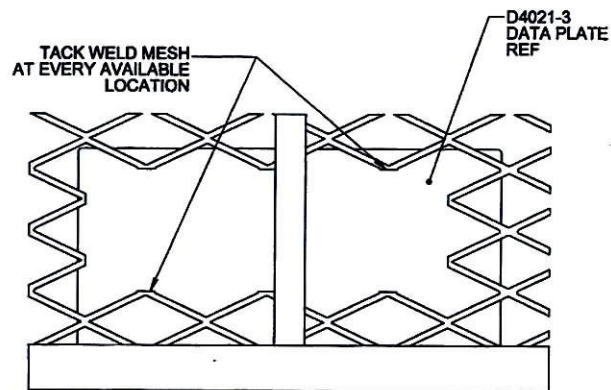
RELEASED
2017-06-07
EN 17-580

APPROVED

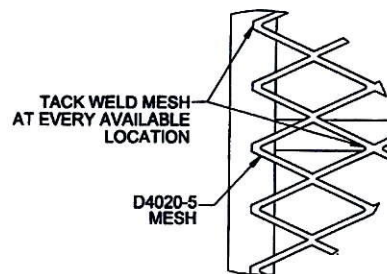
D	SHEET 1: UPDATED NOTE 6 ADDED NOTE 10. D2728-3 DELETED. SHEET 2: SECTION AND VIEW LETTERS UPDATED. ADDED VIEW E-E. (PAR15-418)	AJS	18.11.21
C	REFER TO SHEET 3 D4035-041 DELETED AND REPLACED BY D4035-043. REASON: PROPARIM NO LONGER OFFERED.	AJS	13.03.13
B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3914	SHEET 1 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LONG BASKET LID ASSY (350)	NTS
DATE	16.11.21	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



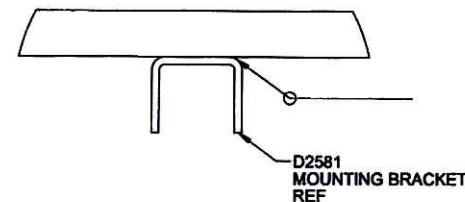
8 7 6 5 4 3 2 1



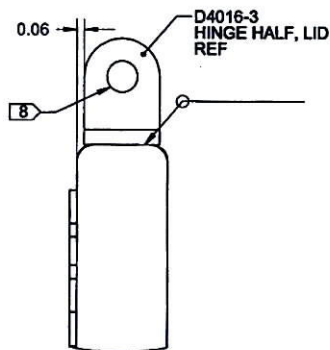
VIEW A-A
SCALE 4X



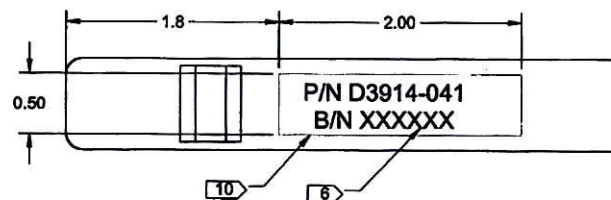
DETAIL B
SCALE 4X



DETAIL C
SCALE 4X
2 PL



DETAIL D
SCALE 8X
3 PL



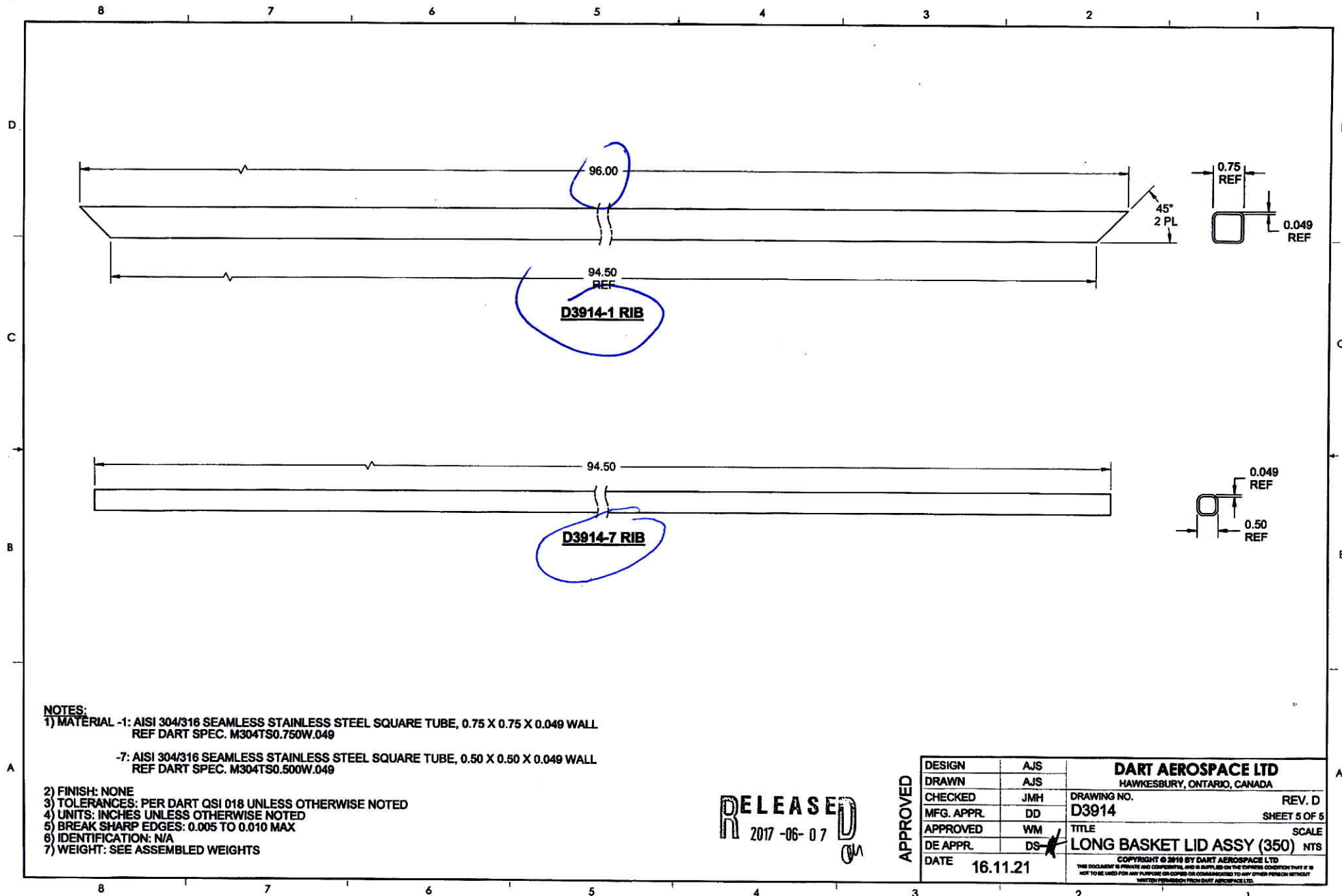
VIEW E-E
SCALE 8X

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3914	SHEET 3 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LONG BASKET LID ASSY (350)	NTS
DATE	16.11.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED
2017-06-07

APPROVED

8 7 6 5 4 3 2 1



Tuesday, July 11, 2017 1:03:30 PM

All amounts are calculated in domestic currency.

All Item ID/GL/WOs All Rec. Employees All Currencies

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VU-EAG001	Eagle Stainless								
PO35151	2		M304TS0.500W.049 f		7/11/2017	7/10/2017	605.0000		0.0000	0	\$0.00
USD	No		Square Tubing	f	600.0000	PLOU01			0.0000	0	
			m137992								
				DAS 9 9-89							
Total Received Quantity:											605.0000
Total Qty to Inspect (PO U/M):											0.0000
Total Reject Quantity:											0.0000
Total Receipt Value:											
Total Balance Due Quantity:											0.0000



EAGLE STAINLESS

Tube and Fabrication, Inc. 10 Discovery Way Franklin Industrial Park Franklin MA 02038

Tel: 800-528-8650 / 508-528-8650 Fax: 800-520-1954 / 508-520-1954 Email: eagle@eagletube.com Web: www.eagletube.com

Packing List

Bill Dart Aerospace, Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace, Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

PO Number: PO35151

Shipment No: 131610
Shipment Date: 06/22/17
Order Number: 136891
Order Date: 02/08/17

Customer Code: 000000001912
Phone: (613) 632-5200
Terms: Net 30 Days

Ship Via: FedXFrCol#94011728

<u>Open</u>	<u>Quantity</u>	<u>Shipped</u>	<u>Back Ord</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Job Number</u>
1,807	605	1,202			FT	1912-SQ0500049T304 1304 Smls Square Tubing 500" x 500" x .049" Wall x (240) - 117" + 500"/-000 Lengths) As Drawn Temper Chem to AS1M A269 Certs Required Pack to Protect NOT an Aerospace Application . NOT Defars Material - Chantal Lavoie 12/02/15.)	136891-01

500 27-11



EAGLE STAINLESS

Tube & Fabrication, Inc.

10 Discovery Way, Franklin, Massachusetts 02038
Tel: 508-528-8650 800-528-8650 Fax: 508-520-1954 800-520-1954
E-mail: generalsales@eagletube.com

Invoice

Bill To: Dart Aerospace, Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship To: Dart Aerospace, Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

PO Number: **PO35151**

Invoice Number: 190904

Salesman: JOHN ROSS

Invoice Date: 06/22/17

Packing List: 131610

Customer: 000000001912

SHIP VIA: Shipped Via FEDEX FRT COLL 94011728

Order No: 136891

Terms: **Net 30 Days**

Item	Quantity	Description	Unit Price	Amount
1	605	1912-SQ05000491304 - T304 Sm's Square Tubing 500" x 500" x .049" Wt x (240) - 117" + .500" / - .000 Lengths.) As Drawn Temper. Chem to ASTM A269. Certs Required. Pack to Protect	\$6 5500 / FT	\$3,962.75

NOT an Aerospace Application NOT Defars Material -
Chantal Lavoie 12/02/15.)

Sub-total: **\$3,962.75**

Sales Tax: **\$0.00**

Shipping and Handling Charges: **\$0.00**

Invoice Total: **\$3,962.75**

EAGLE ALSO ACCEPTS PAYMENT BY VISA, MASTERCARD OR A

AS9100 / ISO9001: CERTIFIED

ISO 13485: CERTIFIED



EAGLE STAINLESS

Tube and Fabrication, Inc

Franklin Industrial Park 10 Discovery Way Franklin, MA 02038

Telephone: (508) 528-8650 or (800) 528-8650 Fax: (508) 520-1954 or (800) 520-1954 Website: www.eagletube.com Email: info@eagletube.com

MATERIAL TEST REPORT CERTIFICATE OF CONFORMANCE

SOLD TO: Dart Aerospace, Ltd.
ADDRESS: 1270 Aberdeen Street
Hawkesbury ON K6A 1K7
DATE: 6/22/2017
PURCHASE ORDER: PO35151
OUR ORDER#: 136891
PART # N/A
REVISION: N/A

HEAT #: 624005
SOURCE: 50-55504-03-17
ITEM: 500 X 500 SQUARE TUBING X .049 WALL T304/304L SMLS
Spec: ASTM A269-15a/A213-15c CHEMISTRY ONLY
Temper: AS DRAWN TEMPER
Quantity: 605 **Units:** FT

DAS
9
9-89

C: .006	Ti: -	Yield (PSI): -
Si: .462	Cb: -	Tensile (PSI): -
Mn: 1.109	Ta: -	Elong. (% IN 2"): -
P: .030	Fe: balance	Hardness (Rockwell): -
S: .004	Cu: .35	Flattening: -
Ni: 8.94	Al: -	Flaring: -
Cr: 18.30	N: .032	Rev F/B: -
Mo: .314	Co: .149	Flange: -
Misc Chem 1: -		Int C/E: -
Misc Chem 2: -		Eddy Current: -
Misc Chem 3: -		Hydrostatic: -
		Grain Size: -

Note 1: MELT: FRANCE
Note 2: MFG: USA
Note 3: MERCURY FREE
Comments:

Conforms to all drawing and/or specification requirements. To the best of our knowledge the material is mercury free, and compliant with Directive 2011/65/EC and 2006/122/ECOF regarding the Restriction of Hazardous Substances (RoHS), and is conflict free per Dodd-Frank section 1502. Reports governing this material are on file.

Bernie Pearson

EAGLE STAINLESS TUBE AND FABRICATION INC.
Bernie Pearson
Quality Assurance Manager

Int.

AA

6/22/2017

Date

PURCHASE MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBING
 DAS

FINISH: ASTM A554 MILL FINISH
 OR ASTM A269 MILL FINISH $\frac{1}{2} \times .049$

WHERE: A.AAA = WIDTH IN INCHES
 .TTT = WALL THICKNESS IN INCHES

PART NUMBER: M304TS | A.AAA | W | .TTT
 | WIDTH | WALL

PART NUMBER: EG. 0.75" X 0.75" X 0.049 WALL = M304TS0.750W.049

RELEASED
 2014-05-26
nd

D	"SEAMLESS" REMOVED FROM PURCHASE MATERIAL SPECIFICATION (SEE NCR14-3818)	DS	14.05.20
C	"SEAMLESS" ADDED TO PURCHASE MATERIAL. ASTM A269 ADDED TO FINISH. REASON: SPEC ADDED FOR 1/2" TUBING	AJS	08.10.18
B	DRAWING MOVED TO "B" SIZE BORDER. FINISH ADDED (SEE NCR 08-045 FOR DETAILS).	AJS	08.08.28
A	NEW ISSUE	DS	01.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	M304TS	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	304/316 SQUARE TUBING	NONE
DATE	14.05.20	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS RELEASED AND IS SUPPLIED BY THE COMPANY UNDER THE CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M304T50.500W.049

PO / BATCH NO.: P035151/M137892

DATE: 17.07.17

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 600'
 QUANTITY INSPECTED: 600'
 QUANTITY REJECTED: 0

THICKNESS ORDERED: .049"
 THICKNESS RECEIVED: .055"
 SHEET SIZE ORDERED: N/A
 SHEET SIZE RECEIVED: N/A

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	(Y) N	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	(Y) N	
CORRECT MATERIAL PER M-DRAWING	(Y) N	ASTM A269
CORRECT THICKNESS	(Y) N	
PHOTO REQUIRED	Y (N)	
CORRECT REF # TO LINK CERT	(Y) N	136391
CORRECT MATERIAL IDENTIFICATION	(Y) N	
CORRECT M# ON THE MATERIAL	(Y) N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL SIZE OF TEST SAMPLE HARDNESS / DUROMETER READING	HRC	HRB	DUR A	DUR D	

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DAS</u> <u>9</u> DATE: <u>17.07.17</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

OUTSTANDING PO REPRINT

Purchase Order ID PO35151

Purchase Order Date 1/31/2017

PO Print Date 7/11/2017

Page Number 1 of 2

Order From : VU-EAG001

EAGLE STAINLESS
10 DISCOVERY WAY
FRANKLIN, MA
US

Ship To : DART AEROSPACE LTD

1270
ABERD
EEN
HAWKE
SBURY,
ON
K6A
1K7
CANAD
A

Contact Name
Vendor Phone 800 528 8650 Ext.800 520 1954
Vendor Fax 800 520 1954
Ship To Contact
Ship To Phone

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB Destination-Collect

Ship Method
Ship Acct

Line Nbr	Item ID Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Extended Price
2	M304TS0.500W.049	Square Tubing DAS 9 9-89	6/26/2017 Yes 6/26/2017	600.00 f	\$3,930.00
MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING AS PER ASTM A554 MILL FINISH OR ASTM A269 MILL FINISH					
Line Total:					\$3,930.00
3	M304TS0.500W.049	Square Tubing	9/21/2017 Yes 9/21/2017	600.00 f	\$3,930.00
MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING AS PER ASTM A554 MILL FINISH OR ASTM A269 MILL FINISH					
Line Total:					\$3,930.00

PO Instructions: DELIVERY DATE TBD
QUOTE NO 974235

6/23/2017



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

OUTSTANDING PO REPRINT

Purchase Order ID PO35151

Purchase Order Date 1/31/2017

PO Print Date 7/11/2017

Page Number 2 of 2

Order From : VU-EAG001
EAGLE STAINLESS
10 DISCOVERY WAY
FRANKLIN, MA
US

Ship To : DART AEROSPACE LTD
1270
ABERD
EEN
HAWKE
SBURY,
ON
K6A
1K7
CANAD
A

Contact Name
Vendor Phone 800 528 8650 Ext.800 520 1954
Vendor Fax 800 520 1954
Ship To Contact
Ship To Phone

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB Destination-Collect

Ship Method
Ship Acct

Line Nbr	Item ID Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Extended Price
4	M304TS0.500W.049	Square Tubing	12/21/2017 Yes 12/21/2017	600.00 f	\$3,930.00

MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING AS PER ASTM A554 MILL FINISH OR ASTM A269 MILL FINISH

Line Total: \$3,930.00

Outstanding PO Total: \$11,790.00

PO Instructions: DELIVERY DATE TBD
QUOTE NO 974235

Terms & Condition of
Purchasing(Suppliers) and
Procurement Quality Clauses are an
integral part of our AS9100

Change Nbr: 3

Change Date: 6/23/2017

WEEK 37

Work Order ID 165249

165249

Page 1

Thursday, August 17, 2017 10:37:19 AM

Item ID: D4035-043 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Lid Rib Assembly, Aft (350 Basket)
Start Date: 8/17/2017 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 8/21/2017 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: Tooling: AUG 17 2017 Date: Run Start *NR1*
QC: 9-89 Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4035	A

100 Weld per dwg A/R S.S. rod Batch: 136585 0.00

100

Large Fab

Large Fab

Memo

2.80

- 1- Cut D4035-3 as per dwg D4035
- 2- Drill holes using DT9563 and chamfer holes as per dwg D4035
- 3- remove identification marks and deburr
- 4- Weld bushing in rib and grind weld flush as per dwg D4035

8x D.M.L 2017-8-30
8x JBL 17-09-06

SEP 13 2017

110 QC10- Inspect visual per QSI004- ground welds 0.00

110

QC

Quality Control

Memo

0.00

8 DAS 24 9-89